GELOY™ RESIN XP4034

REGION ASIA

DESCRIPTION

PC/ASA. Excellent weatherability.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	25	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2510	MPa	ASTM D 790
Hardness, Rockwell R	110	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	320	J/m	ASTM D 256
Izod Impact, notched, -30°C	80	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	47	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	30	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	104	°C	ASTM D 648
CTE, -20°C to 150°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	7.2E-05	1/°C	ASTM E 831
Thermal Conductivity	0.25	W/m-°C	ASTM C177
PHYSICAL			
Specific Gravity	1.15	-	ASTM D 792
Water Absorption, 24 hours	0.25	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 280°C/3.8 kgf	24	g/10 min	ASTM D 1238
OPTICAL			
Gloss, untextured, 60 degrees	94	-	ASTM D 523
FLAME CHARACTERISTICS			
UL Yellow Card Link	E207780-100080704	-	-
INJECTION MOLDING			
Drying Temperature	95 – 105	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.04	%	
Melt Temperature	260 – 275	°C	
Nozzle Temperature	245 – 265	°C	
Front - Zone 3 Temperature	250 – 265	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	245 – 260	°C	
Rear - Zone 1 Temperature	240 – 255	°C	
Mold Temperature	55 – 70	°C	
Back Pressure	0.3 – 1	MPa	
Screw Speed	30 – 80	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.038 – 0.076	mm	
SHEET EXTRUSION			
Drying Temperature	90 – 100	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Minimum Moisture Content	0.04	%	
Melt Temperature	260 – 280	°C	
Barrel - Zone 1 Temperature	225 – 240	°C	
Barrel - Zone 2 Temperature	240 – 250	°C	
Barrel - Zone 3 Temperature	250 – 260	°C	
Barrel - Zone 4 Temperature	260 – 270	°C	
Adapter Temperature	260 – 270	°C	
Die Temperature	260 – 270	°C	
Roll Stack Temp - Top	100 – 120	°C	
Roll Stack Temp - Middle	95 – 110	°C	
Roll Stack Temp - Bottom	75 – 90	°C	

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